

Work Order ID 140465

140465

Page 1

Item ID: D206-559-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206L Series / 407 Bearpaws

Start Date: 1/5/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/19/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: SH Date: 20160105 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
IIN-D206-559	rev L								

100	Document Control	0.00	DAS	6					
100	DOCUMENT CONTROL		9-89	9-89					
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-559-013		CHG006						

160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									

170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

For Stock

MIS ~~FEB 22 2016~~
16-01-07

2x DAS 28 FEB 22 2016
9-89

2x DAS 6 JAN 27 2016
9-89

2x DAS 28 FEB 22 2016
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 140465

140465

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Item ID: D206-559-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206L Series / 407 Bearpaws
 Start Date: 1/5/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/19/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD206-559-013								
	LOCATION: FG013								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

2x ^{DAS} 28 ₉₋₈₉ FEB 22 2016

mc5 FEB 22 2016

mc5 FEB 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 140465

140465

Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

Start Date: 1/5/2016

Required Date: 1/19/2016

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:J04.02.17Blank size changedKJ/JLM
 IPP Rev:K 07-01-02 Was K10008 JLM
 IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC
 IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified
 By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-17A

Purchased

No

160

Each

205.0000

12

24

AN4-17A

Bolt

**

JAN 27 2016

DAS 27
6 9-89

Location

Loc Qty

Loc Code

DAS
28
9-89

over003

150

M133577

100

M133790

50

ST343

55

M132803

55

24

AN4-20A

Purchased

No

160

Each

148.0000

12

24

AN4-20A

Bolt

**

JAN 27 2016

DAS 27
6 9-89

Location

Loc Qty

Loc Code

DAS
28
9-89

GA

24

m116419

24

ST343

124

m132680

74

m133694

50

24

Picklist Print

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Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

Start Date: 1/5/2016

Required Date: 1/19/2016

Start Qty: 2.00

Required Qty: 2.00

D2182B Manufactured No

160 f

544.2733

2.5

5

D2182B

Rubber Cushion - Black (\$Per Foot)

DAS
28
9-89

Location

Loc Qty

Loc Code

ST411

544.2733

130427

194.2733

135093

350

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

D2274 Manufactured No

160 Each

285.0000

12

24

D2274

Radius Block

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

273

138998

273

D2432 Manufactured No

160 Each

1.0000

2

4

D2432

Bearpaw 19" X 24"

DAS
28
9-89

Location

Loc Qty

Loc Code

ST470A

1

133973

1

D2438 Manufactured No

160 Each

44.0000

6

12

D2438

Clamp

DAS
28
9-89

Location

Loc Qty

Loc Code

ST542

44

115202

3

131052

41

DAS
27
9-89
6
9-89

DAS
27
9-89
6
9-89

DAS
27
9-89
6
9-89

DAS
6
9-89

JAN 27 2016

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Work Order ID: 140465

140465

Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

Start Date: 1/5/2016

Required Date: 1/19/2016

Start Qty: 2.00

Required Qty: 2.00

D2529 Manufactured No 160 Each 369.0000 12 24

D2529

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

ST008

369

137534

169

140017

200

D2732 Manufactured No 160 f 255.7134 2.5 5

D2732

Rubber Cushion (\$per foot)

DAS
28
9-89

Location

Loc Qty

Loc Code

ST412

255.7133667

117118

255.713367

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

MS21042L4 Purchased No 160 Each 2,884.000 12 24

MS21042L 4

Locknut

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

41

m133363

41

GA

26

m127813

26

ST260a

56

m130799

56

ST303

2664

m133769

2664

ST305

97

m130922

97

JAN 27 2016

DAS
6
9-89

Picklist Print

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Work Order ID: 140465

140465

Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series / 407 Bearpaws

Start Date: 1/5/2016

Required Date: 1/19/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

160

Each

2,451.000

24

48

NAS1149D0463.J

WASHER

135 134039

**DAS
28
9-89**

Location

Loc Qty

Loc Code

GA

397

M129390

41

M132035

356

ST263

630

M133284

32

M133316

598

ST269

1424

M129682

39

M130799

361

M132317

101

M132677

888

M133077

35

JAN 27 2016

**DAS
6
9-89**

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP